


Date: Wednesday, 5/3/2006 2:08:54 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HANDLE WELDMENT
Job Number :	26924		
Estimate Number :	12050		
P.O. Number :	NIA	Part Number :	D3355047
This Issue :	5/3/2006	Drawing Number :	D3355 REV A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	NIA	Drawing Revision :	A
Previous Run :	NIA	Material :	NIA
Written By :		Due Date :	5/10/2006
Checked & Approved By :		Qty:	4 Um: Each
Comment :	est rev A 06.01.20 new issue EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D33555 medium tubing



made by hand



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 pick: 2.35

M1018TR1-2500.120

9.40
3640

Qty Part number Description Batch
 1 D3355-5 medium tubing M16210

2.35

CPL 06-05-03

2.0 D33557 small tubing



made by hand



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 pick: 6895

275
3647

Qty Part number Description Batch
 1 D3355-7 small tubing M16999

M1018TR1-000W095

CPL 06-05-03

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 Weld assembly as per dwg

CPL 06-06-01

4.0 QC5/9 WELD INSPECTION



JAL-06-21 (4)



Comment: WELD INSPECTION

06/04/01 (4)

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
 Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

DL 06/08/06 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/08/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/3/2006 2:08:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 26924

Part Number: D3355047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P 6/1/12 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51251

P 6/8/18 (4)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Nov.08.22

Job Completion



U 0608.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

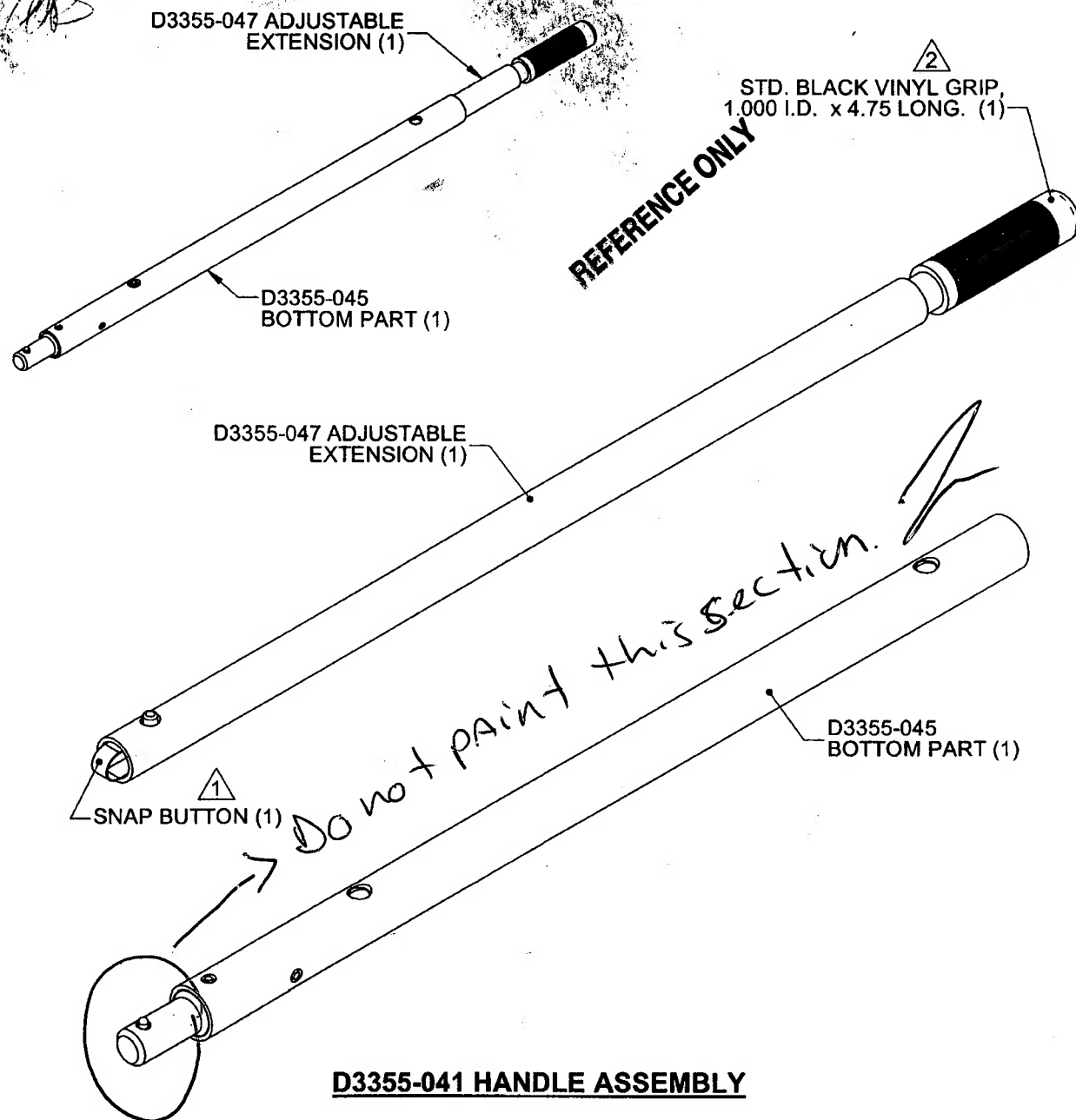
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3355	REV. A SHEET 1 OF 6
DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:8
A	05.02.07	NEW ISSUE	

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06/03/07



NOTES:

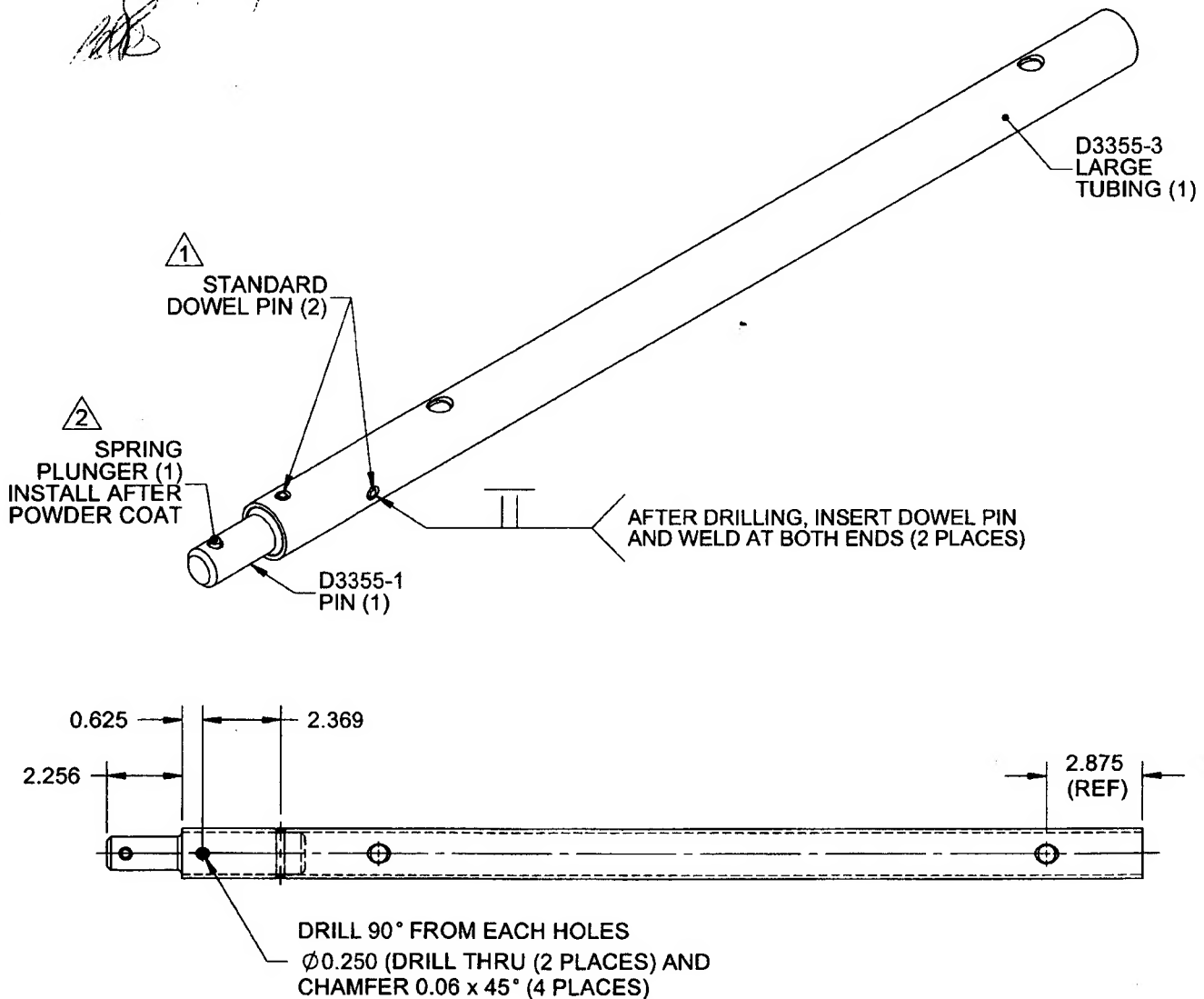
- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:5

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[Signature]**D3355-045 BOTTOM PART****NOTES:**

- 1) STEEL STANDARD GROUND DOWEL PIN, $\varnothing 0.250 \times 1.25$ LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-7130
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

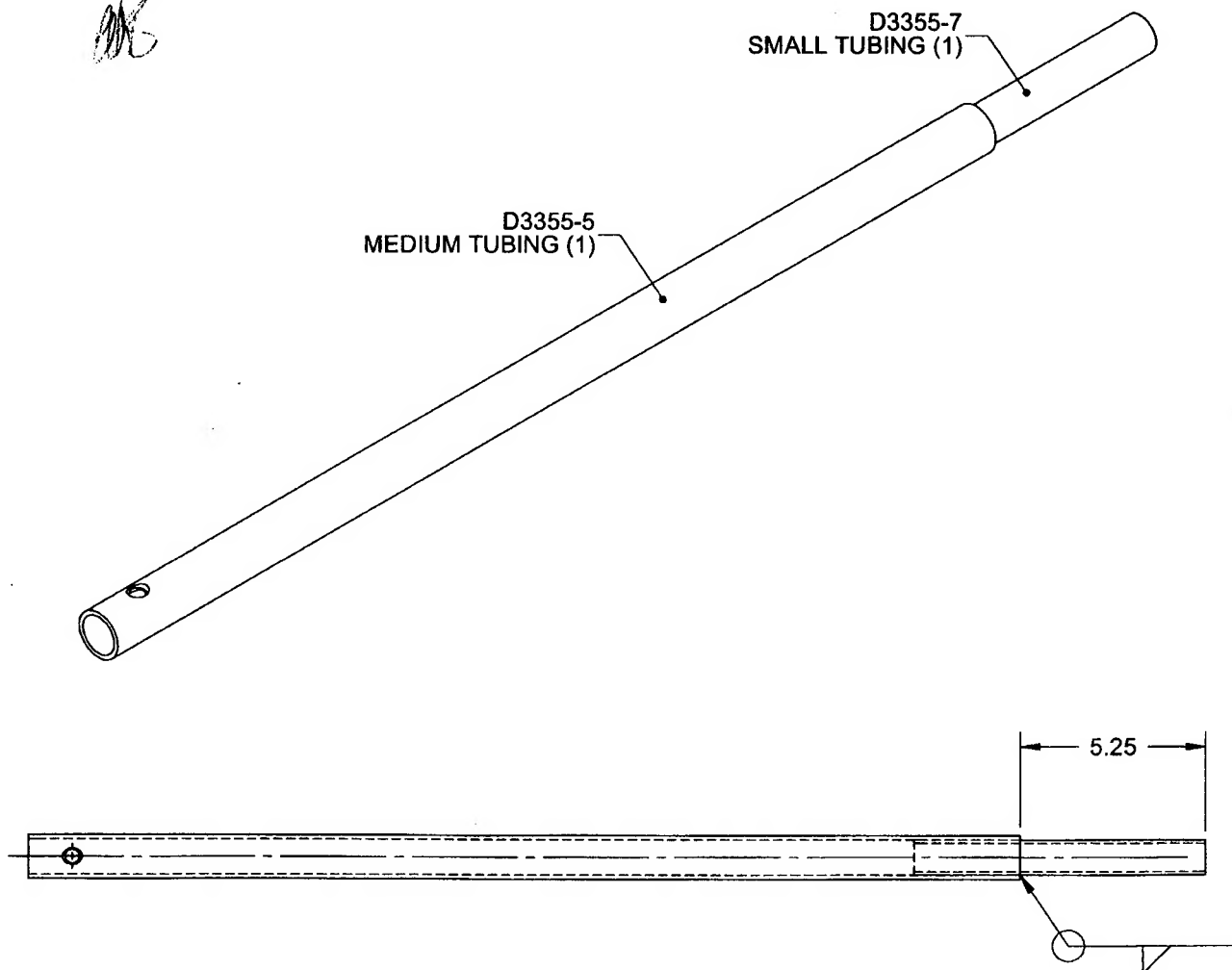
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[Signature]
06/23/09



D3355-047 ADJUSTABLE EXTENSION

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

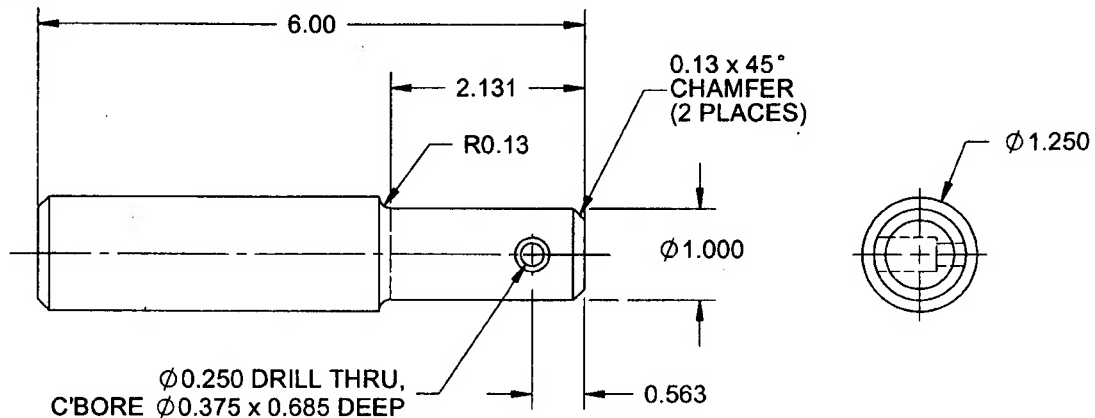
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DATE 05.02.07		TITLE HANDLE WELDMENT	SCALE 1:2

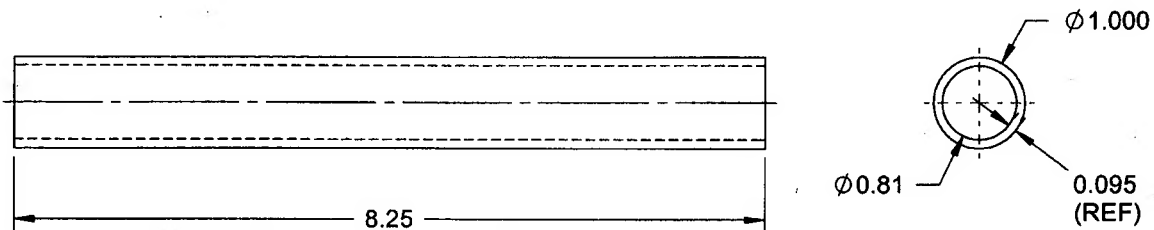
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26/03/07



D3355-1 PIN

D3355-1 NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



D3355-7 SMALL TUBING

D3355-7 NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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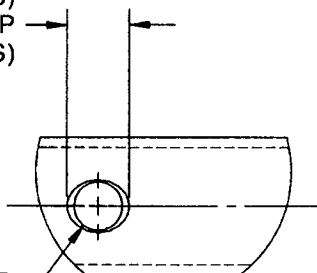
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DATE 05.02.07	TITLE HANDLE WELDMENT		SCALE 1:6

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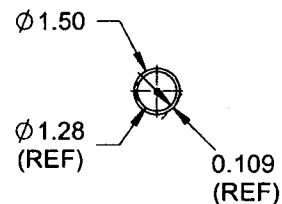
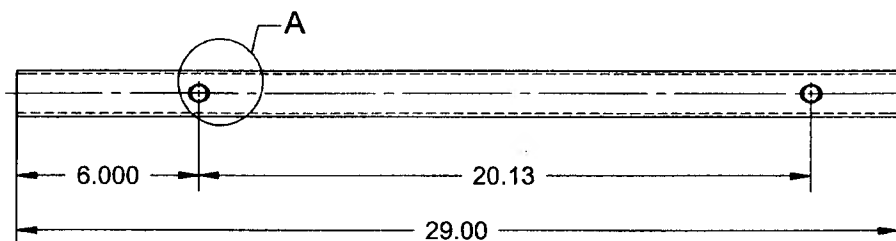
[Handwritten initials]

CHAMFER $\phi 0.687$ (11/16)
x 45°, 0.060 DEEP
(2 PLACES)

$\phi 0.531$ (17/32) DRILL
THRU (2 PLACES)



DETAIL A
SCALE 1 : 2



D3355-3 LARGE TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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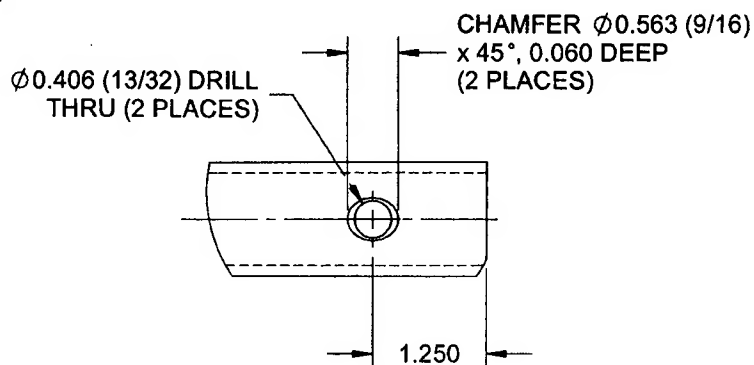
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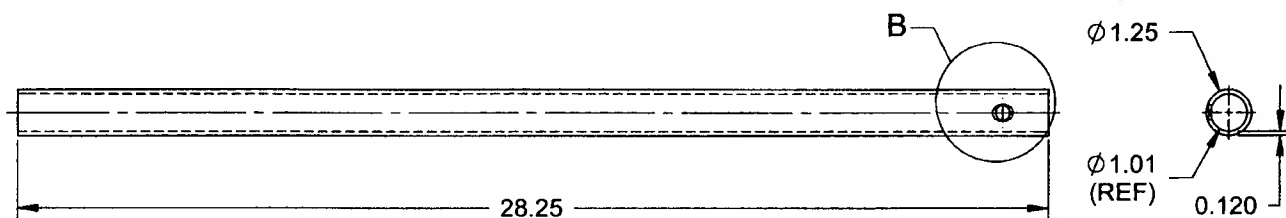
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06/03/09

[Handwritten initials]



DETAIL B
SCALE 1 : 2



D3355-5 MEDIUM TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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